

Date: Thursday, 3/30/2006 10:06:15 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP SPACER
 Job Number : 26452B
 Estimate Number : 10378
 P.O. Number : **NIA**
 This Issue : 3/30/2006 S.O. No. : **NIA**
 Prsht Rev. : NC
 First Issue : **NIA** Type : SMALL /MED FAB
 Previous Run : 26211B
 Part Number : **D30653**
 Drawing Number : D3065 REV. A2
 Project Number : N/A
 Drawing Revision : A2
 Material : **NIA**
 Due Date : 4/15/2006 Qty: 60 Um: Each
 Written By : *See COMMENT Below*
 Checked & Approved By : *06.03.30*
 Comment : Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.2287 sf(s)/Unit Total : 13.7214 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040)

Batch: **B19659**
M19295

2.0 SHEAR SHEAR



Comment: SHEAR

Cut blank: 6.600" x 4.320" Grain along 4.320"

3.0 HAAS Water Jet HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

06.04.12 Cut Machine as per Folio **EA180** and Dwg D3065
 Stack of 15
 Identify as D3065-3

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

06.04.12 **(56)**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Modify step 2 & 3 as shown on p.1	EC	06.04.12			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/30/2006 10:06:15 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 26452B

Part Number: D30653

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr Stack

MA 04/12

(56)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
Bend as per Dwg D3065

SB

06/05/02

SB

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/05/04 (56)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

SA

06/05/03

(56)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB

06/05/03

(56)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *GA*

SB

06/05/03

SB

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

SB

06/05/04

(56)

Job Completion



W 06/05/04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

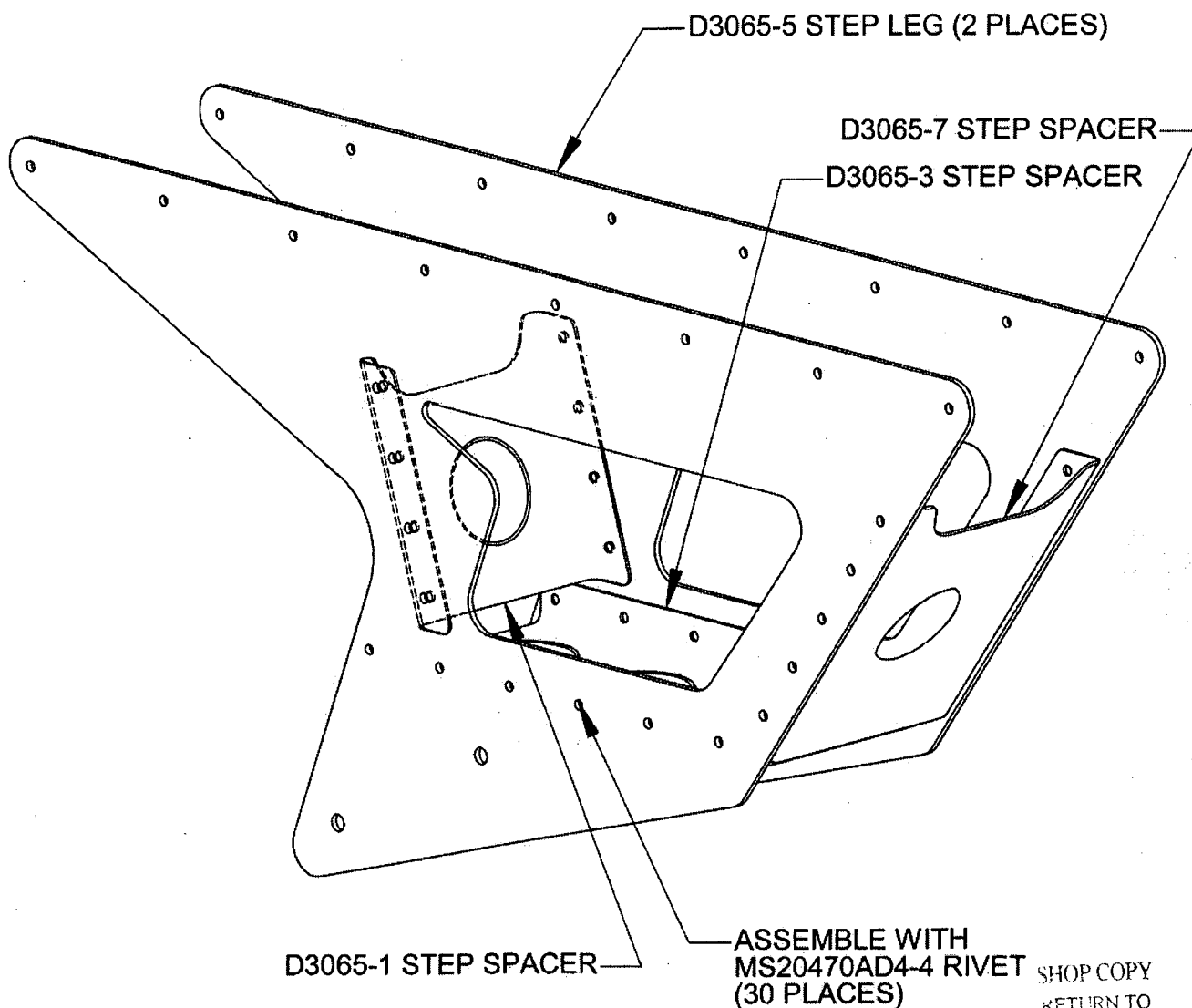
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3065	REV. A SHEET 1 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
A1	03.02.13 CP	ADD SLOTS TO D3065-5	
A2	03.02.27 CP	0.551 WAS 0.410	

RELEASED
02.09.20 #



D3065-041 STEP LEG ASSEMBLY

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WORK ORDER
NO 26452B

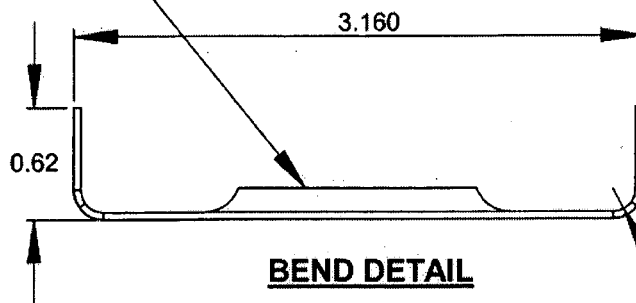
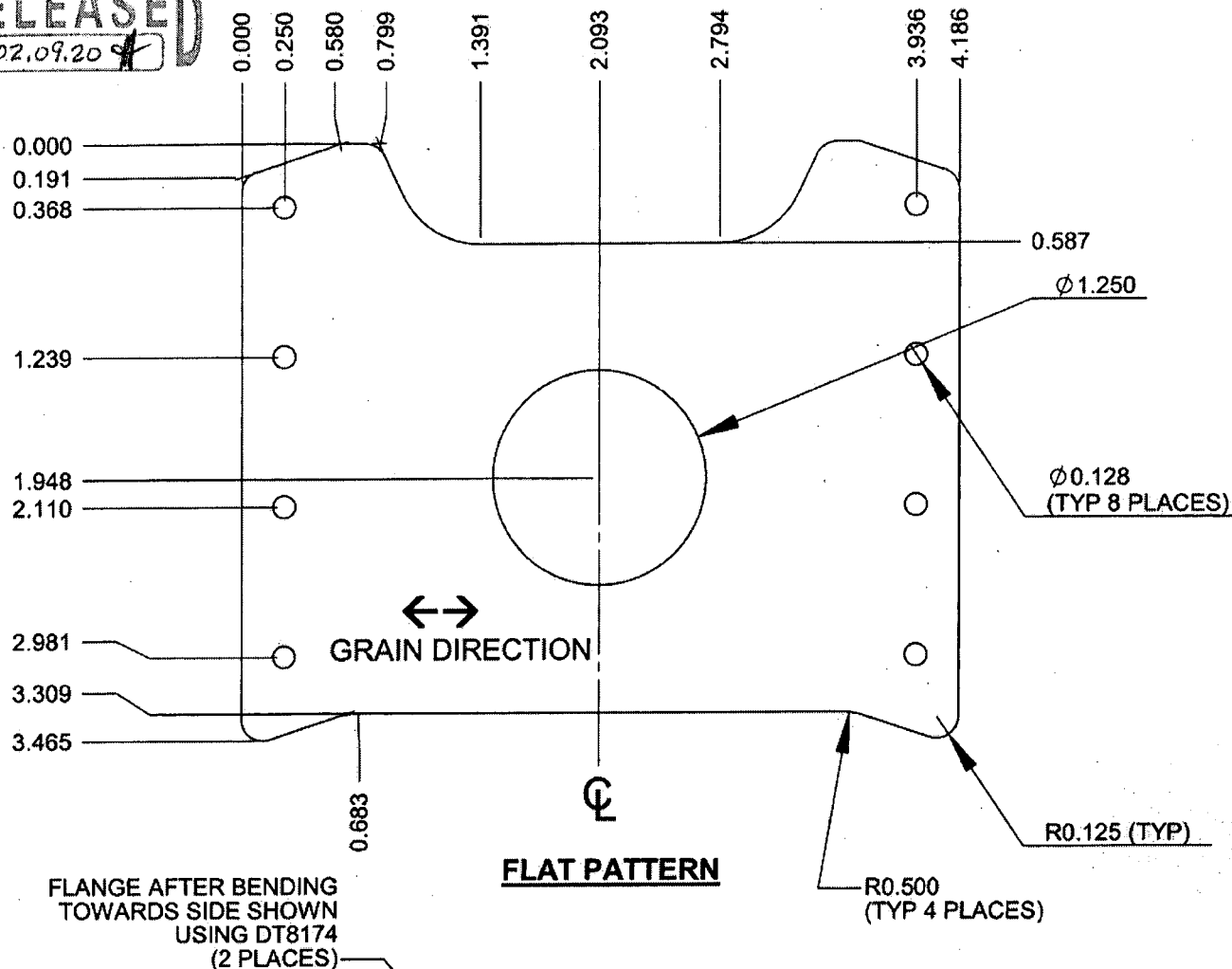
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. A SHEET 2 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. **26452B**

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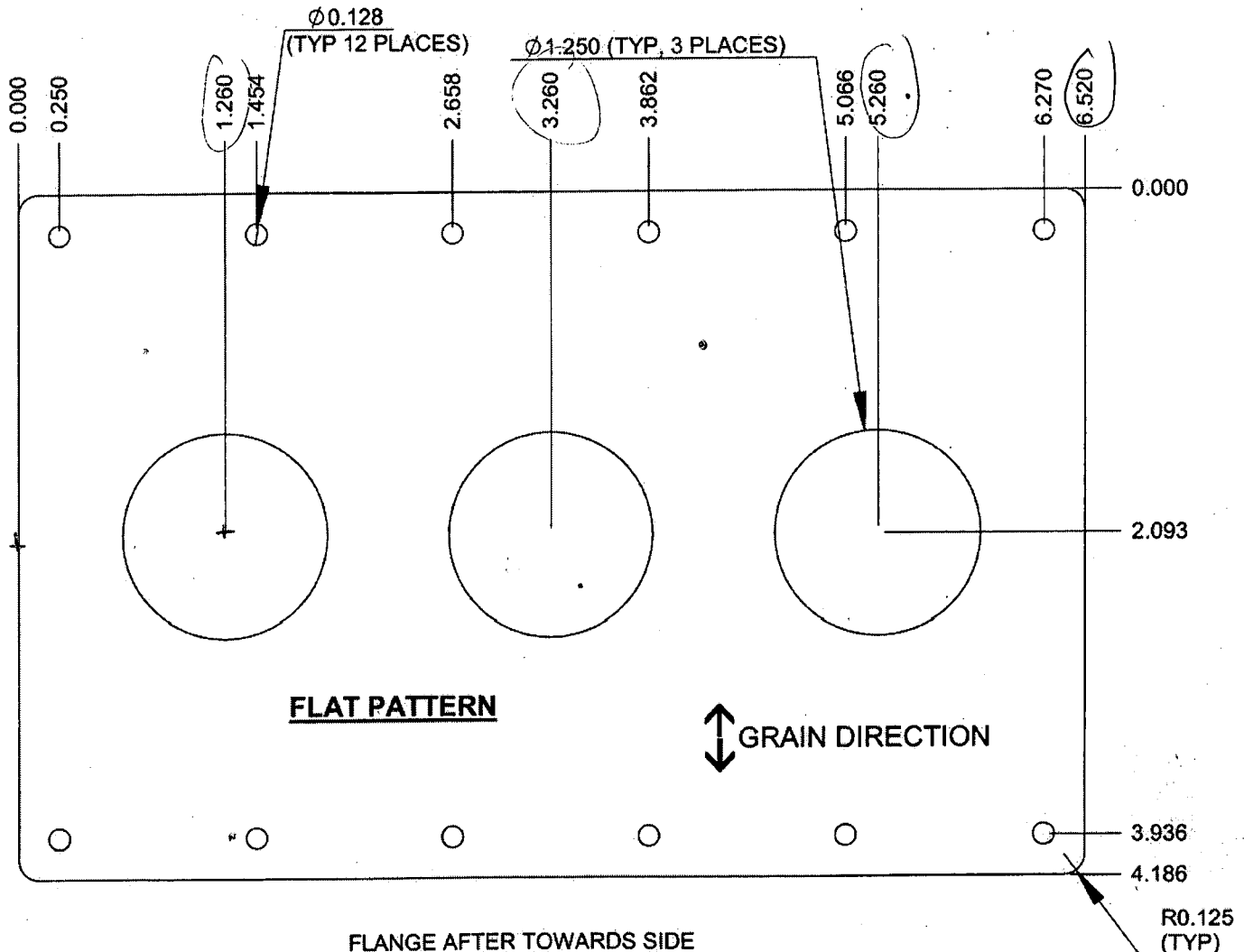
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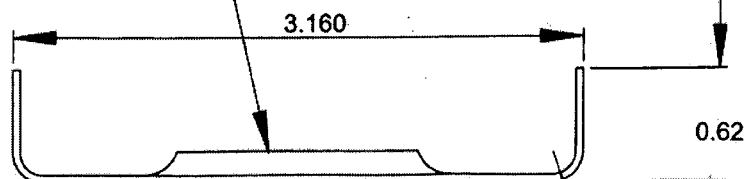
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DATE 02.09.11	TITLE STEP LEG ASSEMBLY		SCALE 1:1



FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
26152B

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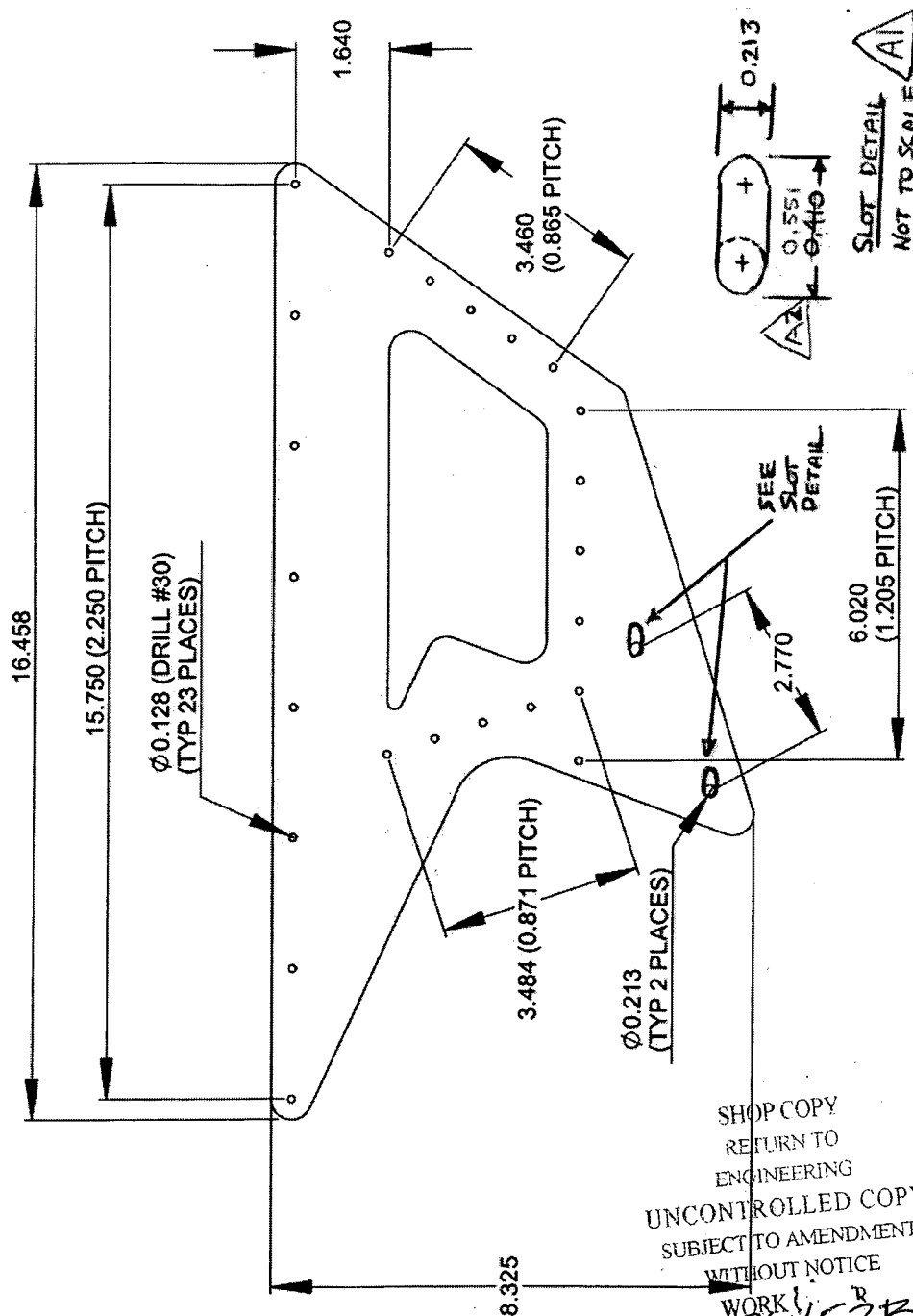
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CHECKED #	APPROVED #	DRAWING NO. D3065	REV. A SHEET 4 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:3

RELEASED
02.09.20 #



D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

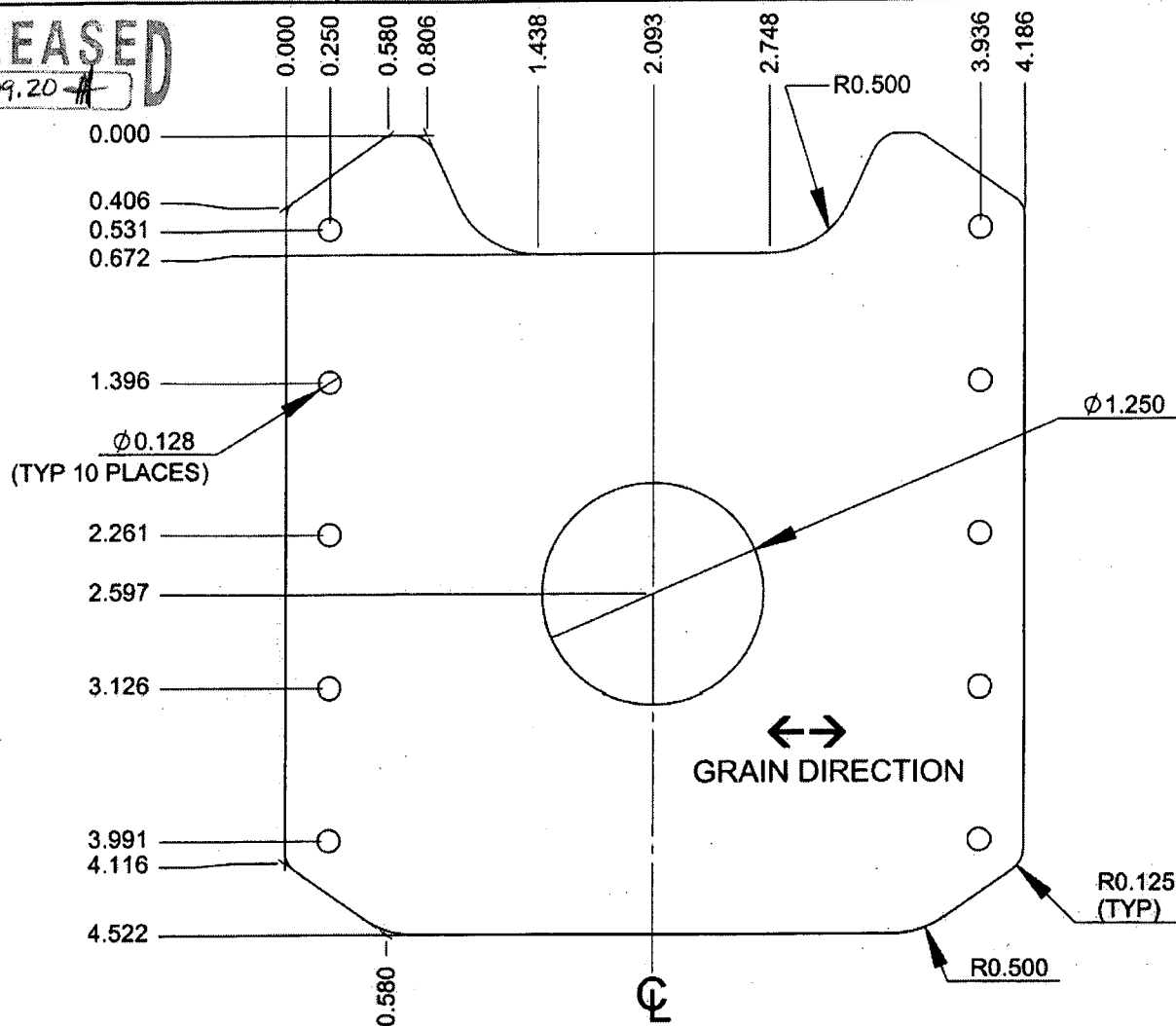
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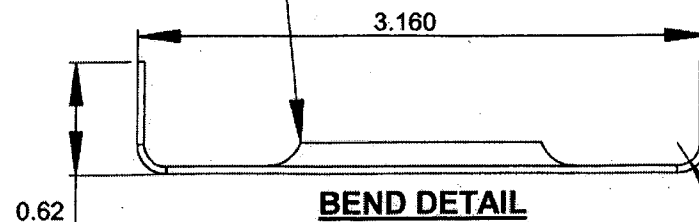
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3065	REV. A SHEET 5 OF 5
DATE 02.09.11		TITLE STEP LEG ASSEMBLY	SCALE 1:1

RELEASED
02.09.20



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

FLAT PATTERN



BEND DETAIL

SHOP COPY

R0.125 (TYP)
ENGINEERING

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 26452B

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